

Work Order ID 119340

119340

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March-23-15 9:45:45 AM

Item ID: D2933-2 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle RH In, 206
 Start Date: 5/15/14 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 5/15/14 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: MCS Date: 1503-23 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2933	Rev C

100 HAAS CNC VERTICAL MACHINING #1 0.00
 100
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1
 Program part number and batch number.1-Inspect part number and batch number are programmed correctly.2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per
 SEE Attached

110 CONVENTIONAL MILLING MACHINE 0.00
 110
 Mill Conv Memo 0.00
 Conventional Milling Machine Machine Keyway and inspect per attached dimension sheet

120 QC1- Inspect dimensions to dimension sheet 0.00
 120
 QC Memo 0.00
 Quality Control

PIO
 Last page

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Item ID: D2933-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle RH In, 206
 Start Date: 5/15/14 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 5/15/14 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							DAS 08 9-89
130									
QC	Memo	0.00							
Quality Control									

140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									

150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>11:00</u> FINISH TIME: <u>11:30</u> OVEN TEMPERATURE: <u>300</u>								

DAS
34
9-89

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Item ID: D2933-2 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle RH In, 206
 Start Date: 5/15/14 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 5/15/14 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				(4)			20 9-89 APR 15 2015
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>S1396</u> Memo	0.00 0.00				4			DAS 27 9-89 APR 16 2015
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							MLJ 15-04-16 mf 15-4-16

Picklist Print

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Parent Item: D2933-2

D2933-2

Parent Item Name: Saddle RH In, 206

Start Date: 5/15/14

Required Date: 5/15/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B00.06.26New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	27.0000	1	4			

D6101-001

Saddle Billet

Location

Loc Qty

Loc Code

MAT042

8

124413

8

MAT045

19

122672

7

125829

12

P 15-03-28

4

DART AEROSPACE LTD	Work Order: 119340
Description: 206 Saddle, Inboard, Right side	Part Number: D2933-2
Inspection Dwg: D2933 Rev. C	Page 1 of 1

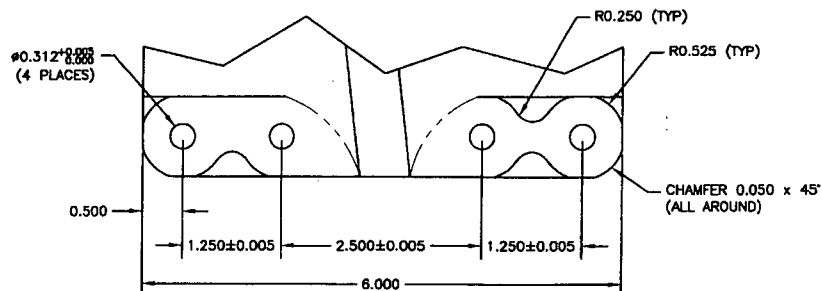
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.118	.125	.122	.123		
B	0.100	0.140		.119	.126	.122	.121		
C	0.100	0.140		.120	.119	.120	.120		
D	0.210	0.230		.217	.218	.220	.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.512	.512	.512	.512		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.257	.257	.257	.257		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.239	.239	.238	.238		
N	0.100	0.140		.121	.120	.121	.120		
O	0.540	0.560		.541	.548	.550	.550		
P	0.490	0.510		.506	.501	.499	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.492	2.492		
S	0.240	0.270		.240	.251	.252	.251		
T	0.100	0.180		.140	.140	.138	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.125	1.145		1.143	1.135	1.136	1.136		
Y	1.565	1.585	DT8695 A/B	1.585	1.575	1.576	1.576		
Z	0.178	0.198		1.583	1.186	1.184	1.185		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J 15-03-29
Date:	

Audited by:	DAS
Date:	15/04/01

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

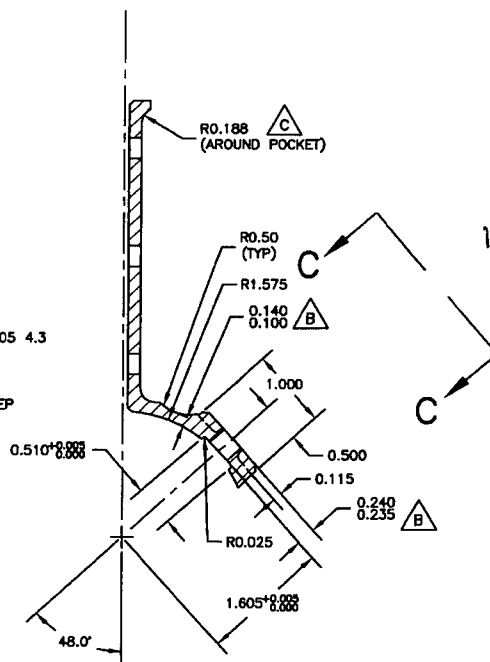


VIEW C-C

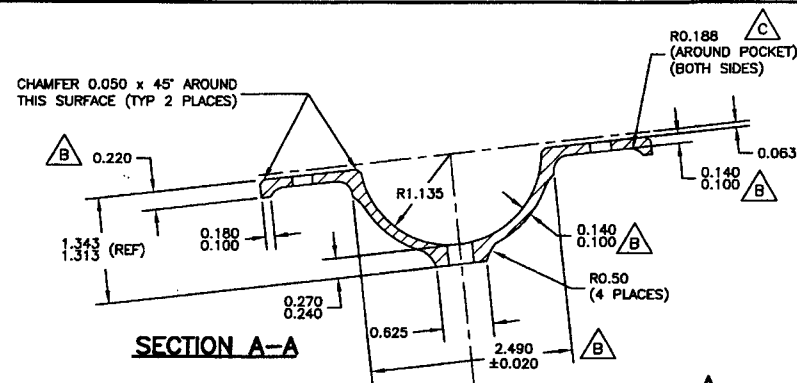
D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

NOTES:

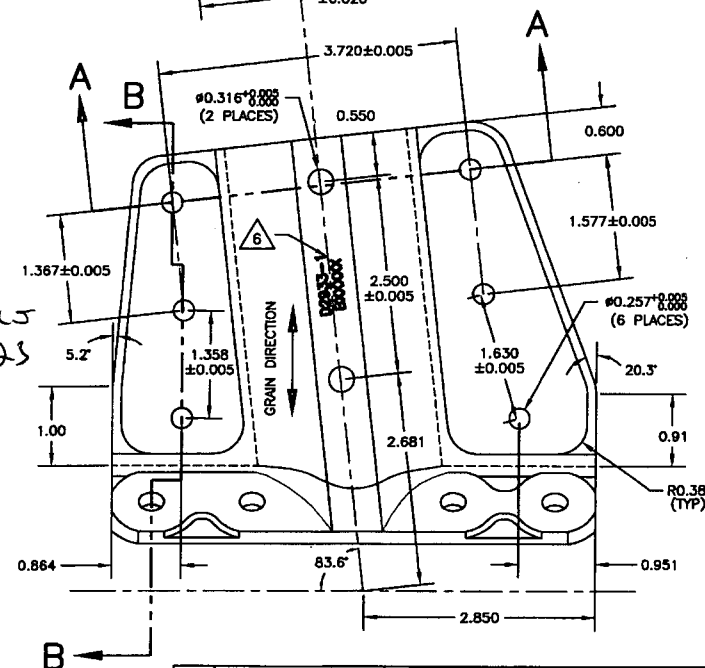
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE INSIDE

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DART AEROSPACE USA, INC.
BELLINGHAM, WA

DRAWING NO. D2933

REV. C
SHEET 1 OF 1

SCALE
2:3

07-02-12

DQA: Aut Date: 15/04/05

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: PD Date: 15/04/17Work Order update only ☐

Work Order: <u>119346</u>	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. <u>D2933-2</u>	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	
NCR No. _____	Scrap ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☒	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	15/4/1	100	1	Dim 0.600 (top flange holes) K 0.594 one side & 0.580 other side. EC. operator not checking the position of the jig before machining saddle	DAS 12 9-89 15/4/1	Test fit with crosstube & skidtube had no problems with bolt installation. Under tolerance edge distance still has <0.71.5. Acceptable.	DAS 12 9-89 15/4/1	DAS 08 9-89 15/04/01	PD 15.04.08
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator ☒									
Offset/Setup ☒									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☒ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved
☐ Crushing	☐ Countersink	☒ Misaligned/off center	☐ Positioned Wrong
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	☐ Pressure/Forced
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	☐ Set-up
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	☐ Temperature/Cure
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	☐ Weld
			☐ Wrong Stock Pulled
			☐ Other